

Work Order ID 73223

Friday, August 26, 2011 10:26:46 AM



Page 1

Item ID: D3240-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Frame

Start Date: 8/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 11/08/20 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3240

Rev B

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3240 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

B 11-8-31

(4)

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B 11-8-31

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

S u l o s / 31

(x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary								
140		0.00							
	Chemical Conversion Coat per QSI005 4.1								
HandFinish	Memo	0.00							
Hand Finishing									
150		0.00							
	QC3- Inspect Part Finish								
QC	Memo	0.00							
Quality Control									

4. BL 11-8-31.

4 6 M 11/08/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73223

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Page 3

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Accept

Revision ID:

Item Name: Frame

Start Date: 8/26/2011 Start Qty: 4.00

Required Date: 9/9/2011 Req'd Qty: 4.00

Reference:

Cust Item ID:




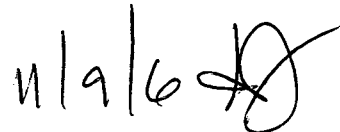
Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Packaging Packaging	Identify as per dwg & Stock Location: <u>5217</u> Memo	0.00 0.00						<u>11-09-01</u>	
170  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						<u>11/9/6</u> 	

MF
11-09-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, August 26, 2011 10:26:44 AM

Page 1

Work Order ID: 73223



Parent Item: D3240-1



Parent Item Name: Frame

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP B 05.04.28 Added Step 6 & 7 KJ/JLM
IPP Rev C now water jet 07-11-01 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.063		Purchased	No			110	sf	163.5000	2.534	10.66947			
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2024-T3 .063 sheet

B11-8-31

Location

Loc Qty

Loc Code

MAT022

163.5

117392

163.5

17392

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

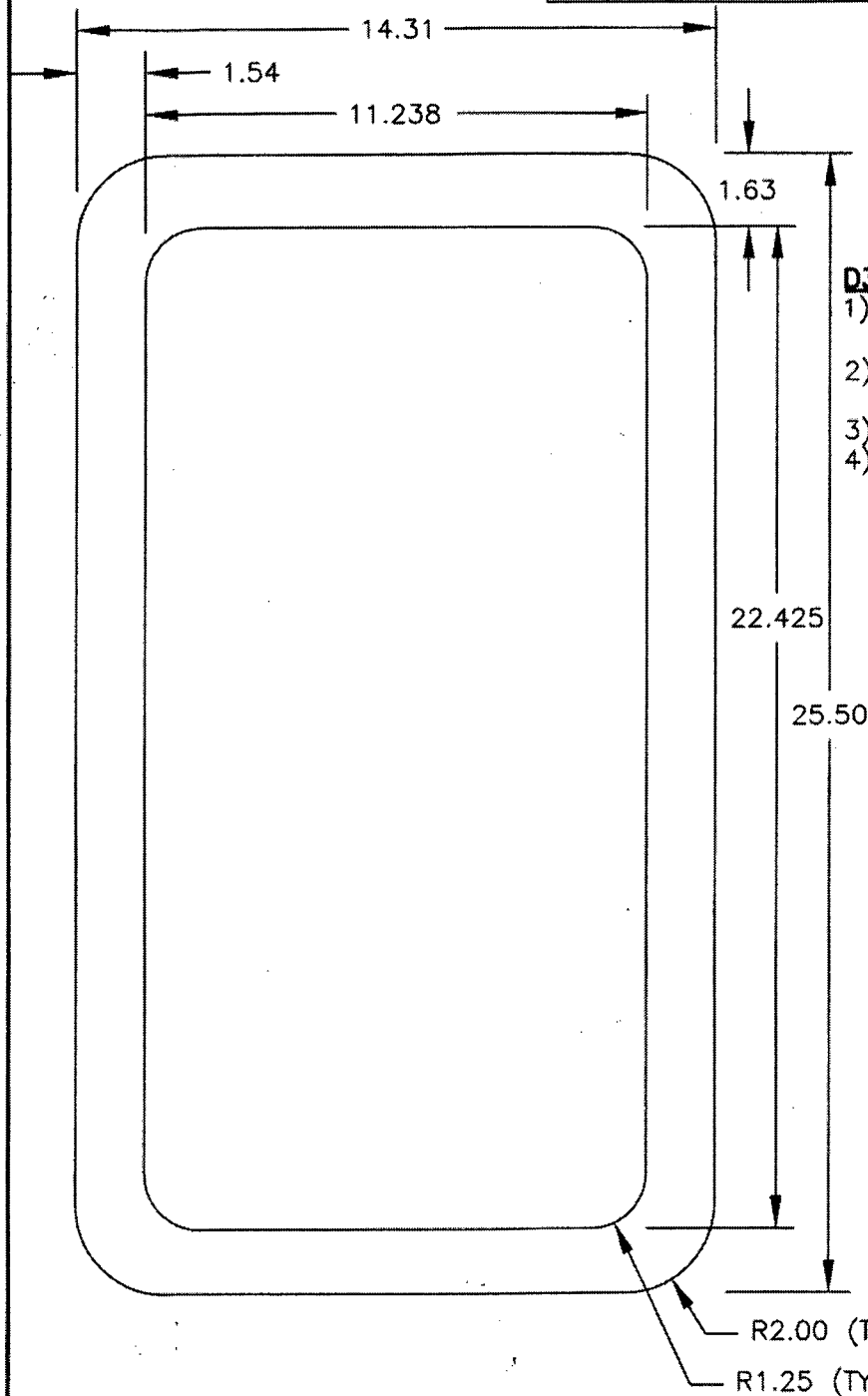
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



DESIGN	UP	DRAWN BY	UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	HA	APPROVED	HA	DRAWING NO. D3240	REV. B SHEET 1 OF 1
DATE	05.01.06	TITLE	FRAME	SCALE	NTS
A	03.12.18	NEW ISSUE			
B	05.01.06	25.50 WAS 25.19; 14.31 WAS 14.19			



RELEASED
05-02-02

D3240-1 FRAME

- 1) MATERIAL: 2024-T3 (QQ-A-250/4), 0.063 THICK (REF. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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